

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

**As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.**



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 6: C08K 5/15, 5/3417, C08L 23/02	A1	(11) International Publication Number: WO 98/29495 (43) International Publication Date: 9 July 1998 (09.07.98)
<p>(21) International Application Number: PCT/US97/07482</p> <p>(22) International Filing Date: 2 May 1997 (02.05.97)</p> <p>(30) Priority Data: 08/773,704 27 December 1996 (27.12.96) US</p> <p>(71) Applicant: MINNESOTA MINING AND MANUFACTURING COMPANY [US/US]; 3M Center, P.O. Box 33427, Saint Paul, MN 55133-3427 (US).</p> <p>(72) Inventors: AMOS, Stephen, E.; P.O. Box 33427, Saint Paul, MN 55133-3427 (US). MOORE, George, G., I.; P.O. Box 33427, Saint Paul, MN 55133-3427 (US). NIELSON, Kent, E.; P.O. Box 33427, Saint Paul, MN 55133-3427 (US). WICKI, Markus, A.; P.O. Box 33427, Saint Paul, MN 55133-3427 (US).</p> <p>(74) Agents: SCHULTE, Daniel, C. et al.; Minnesota Mining and Manufacturing Company, Office of Intellectual Property Counsel, P.O. Box 33427, Saint Paul, MN 55133-3427 (US).</p>		<p>(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, UZ, VN, YU, ARIPO patent (GH, KE, LS, MW, SD, SZ, UG), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</p> <p>Published With international search report. With amended claims.</p>
<p>(54) Title: MODIFYING AGENTS FOR POLYOLEFINS</p> <p>(57) Abstract</p> <p>Modifying agents for polyolefins improve the physical and/or optical properties of the polymers and have formula (I); and salts thereof, wherein X, Y, Z, R and R1 are as defined in the specification.</p> <div data-bbox="941 1113 1396 1470"><p>Chemical structure (I) is a bicyclic system. It features a five-membered ring fused to a six-membered ring. The five-membered ring has substituents X and Y. The six-membered ring has substituents R, R1, and Z. There are two carbonyl groups (C=O) attached to the six-membered ring, one adjacent to R1 and another adjacent to Z. A dashed line indicates a bond between the two rings.</p></div>		

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece			TR	Turkey
BG	Bulgaria	HU	Hungary	ML	Mali	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MN	Mongolia	UA	Ukraine
BR	Brazil	IL	Israel	MR	Mauritania	UG	Uganda
BY	Belarus	IS	Iceland	MW	Malawi	US	United States of America
CA	Canada	IT	Italy	MX	Mexico	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NE	Niger	VN	Viet Nam
CG	Congo	KE	Kenya	NL	Netherlands	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NO	Norway	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	NZ	New Zealand		
CM	Cameroon	KR	Republic of Korea	PL	Poland		
CN	China	KZ	Kazakhstan	PT	Portugal		
CU	Cuba	LC	Saint Lucia	RO	Romania		
CZ	Czech Republic	IJ	Liechtenstein	RU	Russian Federation		
DE	Germany	LK	Sri Lanka	SD	Sudan		
DK	Denmark	LR	Liberia	SE	Sweden		
EE	Estonia			SG	Singapore		

MODIFYING AGENTS FOR POLYOLEFINS

Field of the Invention

The invention is directed to heterocyclic modifying agents that can improve
5 properties of compositions made from polyolefins such as polypropylene. These
modifying agents improve the optical and/or physical properties of polymers and
polymer blends to which they are added. The invention further relates to
compositions that contain a polyolefin and a modifying agent as described herein,
and to methods of improving the optical and physical properties of polyolefins using
10 the modifying agents of the invention.

Background of the Invention

Polyolefins, including polypropylene, are used in a variety of industrial
applications. For some of these applications, such as packaging, storage containers,
15 disposable medical devices, and so on, it is necessary or desirable that the product
or article be optically clear. The optical and physical properties of the polyolefins
are largely dependent upon the number of nucleation sites and the rate of nucleation
during the crystallization process. The nucleation step of the overall crystallization
process for polyolefins such as stabilized polypropylene is generally slow, so that a
20 relatively small number of nucleation sites are formed. These nucleation sites are
the points at which spherulites start to grow during the subsequent crystallization
step. Because the number of sites is low, the spherulites can grow to a large size.
When the size of the spherulites is larger than the wavelength of incident light, the
light scatters and the polyolefin has a hazy appearance.

25 The size of the spherulites can be reduced and the optical properties of the
polyolefin improved by the addition of nucleating and/or clarifying agents
("modifying agents") during processing. These agents increase the number of
nucleation sites, and therefore the rate of nucleation. The size of the spherulites
that form at these sites is smaller and the spherulites are more numerous as a result
30 of this heterogeneous nucleation. If the spherulites are small r in size than the

wavelength of incident light, scattering of the light is substantially reduced and the resin appears clear.

Reduction of spherulite size also affects the physical properties of the polyolefin, e.g. flexural modulus, heat distortion temperature, impact strength and elongation at break of the resin can change with the addition of a modifying agent. The enhanced heterogeneous nucleation raises the crystallization onset temperature of the resin. This can result in a reduced cycle time during processing and greater manufacturing efficiency.

Nucleating and clarifying agents are generally known in the polymer art. U.S. Patent No. 5,135,975 describes clarifying agents commercially known as the Millad™ group of products produced by Milliken Chemicals. These additives, particularly Millad™ 3988 have good organoleptic properties and resist plate-out, but dispersion problems resulting in the appearance of white specks have been encountered by some users. Relatively high process temperatures are needed to prevent the appearance of these white specks. Related clarifiers are described in JP 57-018682 and in JP 86-017834.

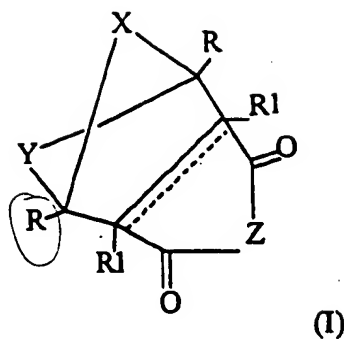
U.S. Patent No. 5,342,868 describes the use of various organophosphorus salts as clarifiers for various crystalline synthetic resins. These additives perform well but their higher cost makes them somewhat less economical for use on a large scale.

There is a need in the art for agents that can be added to polyolefins such as polypropylene that are compatible with the polyolefins and stable under polyolefin processing conditions, that improve the optical and/or physical properties of the polyolefin, and that may be efficiently obtained or produced.

25

Summary of the Invention

We have found that compounds of formula (I) and salts thereof are useful modifying agents for polyolefins, especially as nucleating and/or clarifying agents:



wherein X is selected from

C₁₋₁₈ alkylene,
C₂₋₁₈ alkenylene,
C₃₋₁₈ cycloalkylene,
C₄₋₁₈ cycloalkenylene,
arylene, and
-O-;

5

10 Y is selected from

C₁₋₁₈ alkylene,
C₂₋₁₈ alkenylene,
C₃₋₁₈ cycloalkylene,
C₄₋₁₈ cycloalkenylene, and
arylene;

15

Z is selected from

-O- and -NR₂-;

each R is independently selected from

-H,
C₁₋₁₈ alkyl,
C₃₋₁₈ cycloalkyl,
C₂₋₁₈ alkenyl,
C₄₋₁₈ cycloalkenyl,
-COR₃,
-OH,

20

25

C₁₋₁₈ alkoxy, and
C₁₋₁₈ alkyl substituted by one or more
-OH, halogen, -COR₃, -S-C₁₋₁₈ alkyl,
aryl, or substituted aryl groups;

5

each R₁, if present, is independently selected from

-H,
C₁₋₁₈ alkyl,
C₃₋₁₈ cycloalkyl,
halogen, and
-OH;

10

each R₂ is independently selected from

C₁₋₁₈ alkyl substituted by one or more
-COR₃, and optionally one or more
aryl or substituted aryl,
C₁₋₁₈ alkyl substituted by one or more
-OH, halogen, or -C₁₋₁₈ alkylene-
-S-C₁₋₁₈ alkyl,
-OH,
an other-than-linear-alkyl-substituted
aryl, and
-O-C₁₋₁₈ alkyl, optionally substituted
by NR₄R₅;

15

20

25

each R₃ is independently selected from -OH, -O-C₁₋₁₈ alkyl, -O-aryl, -O-substituted
aryl, or -NR₄R₅;

R₄ and R₅ are independently -H, C₁₋₁₈ alkyl, C₃₋₁₈ cycloalkyl, aryl, or
substituted aryl; or a salt thereof.

Accordingly, the invention provides compositions comprising a polyolefin and an effective nucleating or clarifying amount of a compound of formula (I), or a salt thereof.

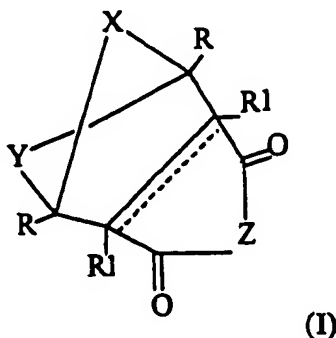
The invention further provides a method of enhancing the crystallinity of a polyolefin by adding an effective amount of a compound of formula (I), or a salt thereof, to the polyolefin.

The compounds of formula (I) act as modifying agents, e.g. nucleating and/or clarifying agents, for polyolefins. A nucleating agent acts to improve the physical properties of the polyolefin such as strength, weatherability, solvent resistance, heat deflection temperature and so on by providing sites for crystal formation, resulting in formation of increased numbers of spherulites. If the spherulites are sufficiently large to scatter visible light, the polyolefin material will not be optically clear. A clarifying agent provides compositions that are more optically clear by causing the formation of spherulites that are sufficiently small that they scatter less visible light. Generally, the different physical properties of the polyolefin such as the yield stress and impact resistance tend to vary as the spherulites become smaller in size, so that the desired optical clarity and physical properties should be balanced when determining the type and amount of modifying agent to use.

20

Detailed Description of the Invention

The modifying agents of the invention are compounds of formula (I):



25 wherein X is selected from

C₁₋₁₈ alkylene,

5

C₂₋₁₈ alkenylene,
C₃₋₁₈ cycloalkylene,
C₄₋₁₈ cycloalkenylene,
arylene, and
-O-;

Y is selected from

10

C₁₋₁₈ alkylene,
C₂₋₁₈ alkenylene,
C₃₋₁₈ cycloalkylene,
C₄₋₁₈ cycloalkenylene, and
arylene;

Z is selected from

15 each R is independently selected from

-O- and -NR₂-;

20

-H,
C₁₋₁₈ alkyl,
C₃₋₁₈ cycloalkyl,
C₂₋₁₈ alkenyl,
C₄₋₁₈ cycloalkenyl,
-COR₃,
-OH,
C₁₋₁₈ alkoxy, and
C₁₋₁₈ alkyl substituted by one or more
-OH, halogen, -COR₃, -S-C₁₋₁₈ alkyl,
aryl, or substituted aryl groups;

25

each R₁, if present, is independently selected from

30

-H,
C₁₋₁₈ alkyl,
C₃₋₁₈ cycloalkyl,

halogen, and

-OH;

each R2 is independently selected from

5

C₁₋₁₈ alkyl substituted by one or more

-COR3, and optionally one or more

aryl or substituted aryl,

C₁₋₁₈ alkyl substituted by one or more

-OH, halogen, or -C₁₋₁₈ alkylene-

10

-S-C₁₋₁₈ alkyl,

-OH,

an other-than-linear-alkyl-substituted

aryl, and

-O-C₁₋₁₈ alkyl, optionally substituted

15

by NR4R5;

each R3 is independently selected from -OH, -O-C₁₋₁₈ alkyl, -O-aryl, -O-substituted aryl, or -NR4R5;

20 R4 and R5 are independently -H, C₁₋₁₈ alkyl, C₃₋₁₈ cycloalkyl, aryl, or substituted aryl; or a salt thereof.

In the above formulas each alkyl, alkenyl, alkylene and alkenylene group can be straight or branched. For example, "C₁₋₁₈ alkyl" includes methyl, ethyl, n-propyl, i-propyl, n-butyl, s-butyl, i-butyl, t-butyl, and so on. The cycloalkyl, cycloalkenyl, aryl, cycloalkylene, cycloalkenylene, and arylene groups include groups that are

25 alkyl substituted, up to the specified number of carbon atoms.

"Aryl" includes carbocyclic and heterocyclic aryl, but is preferably carbocyclic aryl, most preferably phenyl.

"Heterocyclic aryl" includes, for example, pyrrolyl, imidazolyl, indolyl, pyridyl, thiophenyl, furyl, and the like.

"Substituted aryl" includes any carbocyclic or heterocyclic aryl group substituted as desired, for example by one or more hydroxy, alkyl, cycloalkyl, alkoxy, or halogen.

An "other-than-linear-alkyl-substituted" aryl includes carbocyclic and heterocyclic aryl groups substituted by one or more substituted group that is not a linear alkyl group. The substituted group that is not a linear alkyl group can be, for example, hydroxy, cycloalkyl, alkoxy, acids such as carboxylic acid, and halogen groups. This can include such aryls that are additionally substituted by one or more alkyl group.

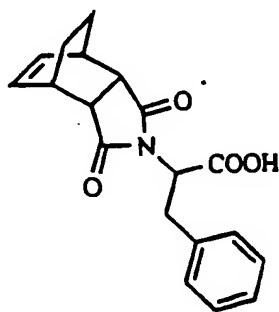
Each ring in the compound has a maximum of 8 ring atoms.

Many compounds useful in the invention contain one or more chiral centers. In this instance the invention includes each enantiomer or diastereomer as well as mixtures (e.g. racemic mixtures) of the enantiomers or diastereomers.

For fused ring systems, such as those wherein X and/or Y are divalent cyclic groups, attachment at the 1 and 2 positions is preferred, although other types of fusion such as 1,1 and 1,3 are possible.

A preferred class of modifying agents includes the compounds of formula (I) wherein X is C_{1-18} alkylene and Y is C_{1-18} alkenylene.

One preferred modifying agent is N-(1'-carboxy-2'-phenylethyl)-bicyclo[2.2.2]oct-5-en-2,3 dicarboximide which has the following structure:



The modifying agent can be included in a composition of the present invention in an amount sufficient to provide desired optical and/or physical properties to the composition. Preferably, the modifying agent can be present in an

amount in the range from about 0.001 to 1 wt-% based on the total composition weight, more preferably from about 0.15 to 0.7 wt-%.

The modifying agents useful in the invention are known and commercially available, or can be readily synthesized from commercially available materials using methods known in the chemical art.

The modifying agents of the invention can improve physical properties of polyolefins such as polypropylene, as well as polyolefin copolymers derived from monomers comprising at least one olefinic monomer. The polyolefins can generally have a melt flow rate in the range from about 1 to 70, preferably about 7 to 35g/10 min according to ASTM D-1238.

Polyolefins useful in the composition of the invention include polymers and copolymers derived from one or more olefinic monomer of the general formula $\text{CH}_2=\text{CHR''}$, wherein R'' is hydrogen or C_{1-18} alkyl. Examples of such olefinic monomers include propylene, ethylene, and 1-butene, with propylene being generally preferred. Representative examples of polyolefins derived from such olefinic monomers include polyethylene, polypropylene, polybutene-1, poly(3-methylbutene), poly(4-methylpentene) and copolymers of ethylene with propylene, 1-butene, 1-hexene, 1-octene, 1-decene, 4-methyl-1-pentene, and 1-octadecene.

The polyolefin may optionally comprise a copolymer derived from an olefinic monomer and one or more further comonomers that are copolymerizable with the olefinic monomer. These comonomers can be present in the polyolefin in an amount in the range from about 1 to 10 wt-% based on the total weight of the polyolefin. Useful such comonomers include, for example, vinyl ester monomers such as vinyl acetate, vinyl propionate, vinyl butyrate, vinyl chloroacetate, vinyl chloropropionate; acrylic and alpha-alkyl acrylic acid monomers, and their alkyl esters, amides, and nitriles such as acrylic acid, methacrylic acid, ethacrylic acid, methyl acrylate, ethyl acrylate, N,N-dimethyl acrylamide, methacrylamide, acrylonitrile; vinyl aryl monomers such as styrene, o-methoxystyrene, p-methoxystyrene, and vinyl naphthalene; vinyl and vinylidene halide monomers such as vinyl chloride, vinylidene chloride, and vinylidene bromide; alkyl ester monomers of maleic and fumaric acid such as dimethyl maleate, and diethyl maleate;

vinyl alkyl ether monomers such as vinyl methyl ether, vinyl ethyl ether, vinyl isobutyl ether, and 2-chloroethyl vinyl ether; vinyl pyridine monomers; N-vinyl carbazole monomers, and N-vinyl pyrrolidine monomers.

The polyolefin may also contain a metallic salt form of a polyolefin, or a
5 blend thereof which contains free carboxylic acid groups. Illustrative of the metals which can be used to provide the salts of said carboxylic acid polymers are the one, two and three valence metals such as sodium, lithium, potassium, calcium, magnesium, aluminum, barium, zinc, zirconium, beryllium, iron, nickel and cobalt. Preferred polyolefins include polypropylene homopolymers and copolymers of
10 propylene with ethylene, 1-butene, 1-hexene, 1-octene, 4-methyl-1-pentene, vinyl acetate, or methyl acrylate.

The polyolefins can also include blends of these polyolefins with other polyolefins or copolymers or blends thereof containing conventional adjuvants such as antioxidants, light stabilizers, acid neutralizers, fillers, antiblocking agents and
15 pigments.

Representative blends of polyolefins useful in this invention include blends of polyethylene and polypropylene, low density polyethylene and high-density polyethylene, and polyethylene and olefin copolymers derived from an olefinic monomer and one or more of the above-described optional copolymerizable
20 comonomers, e.g., ethylene and acrylic acid copolymers; ethylene and methyl acrylate copolymers; ethylene and ethyl acrylate copolymers; ethylene and vinyl acetate copolymers; ethylene, acrylic acid, and ethyl acrylate copolymers, and ethylene, acrylic acid, and vinyl acetate copolymers.

The modifying agent may be incorporated into the polyolefin using any
25 method that does not cause significant degradation or vaporization of the modifying agent. This can be accomplished using any mixing method that is convenient, such as a melt mixer, an extruder, and the like. The modifying agent may be dry blended with the polyolefin in flake, granule, or pellet form; a liquid melt, dispersion, suspension or solution of the modifying agent may be combined with the polyolefin
30 in flake, granule, or pellet form; or a concentrated blend of the modifying agent a polyolefin may first be prepared and then blended with the polyolefin to obtain a

final desired concentration of modifying agent. If such a concentrated blend is prepared the modifying agent can be present in the concentration blend in an amount in the range from about 0.5 to 5 wt-%.

5 If desired, components may be added to the polyolefin in addition to the modifying agent. Examples of such components include pigments, antioxidants, acid neutralizers, antistatic agents, ultraviolet light absorbers, and hindered amine stabilizers.

The modifying agent can be added to the polyolefin at any time during processing of the polyolefin, so long as adequate dispersion of the modifying agent
10 is obtained before the polyolefin begins to crystallize.

The polyolefin containing a desired amount of modifying agent can be formed into articles as desired in any manner known in the art. For example the polymer can be injection molded, extruded, thermoformed, compression molded, and so on to form desired shapes and articles.

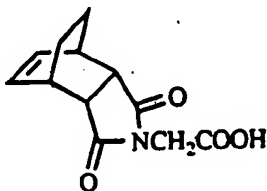
15 The invention is further described by reference to the following examples, which are understood to be illustrative and not limiting of the invention.

Examples

Preparative Example 1

20

N-carboxymethyl-bicyclo[2.2.2]oct-5-en-2,3-dicarboximide



25

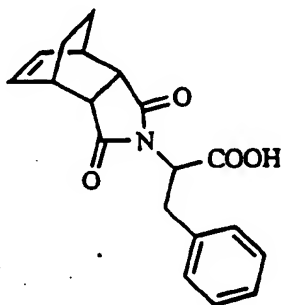
To a suspension of bicyclo[2.2.2]oct-5-en-2,3-dicarboxylic anhydride (688 mg, 3.9 mmol) in H₂O (10 mL) was added glycine (348 mg, 4.6 mmol), and a solution of K₂CO₃ (321 mg, 2.3 mmol) in H₂O (2 mL). The mixture was heated to reflux temperature and allowed to react for 4 hrs. After cooling to room temperature, the mixture was acidified with conc. HCl until the pH reached 1 and

extracted with ethyl acetate (EtOAc). The organic layer was washed with brine and dried over Na_2SO_4 . Removal of the solvent gave a colorless solid which was recrystallized from EtOAc/hexane to yield the product as colorless crystals: 653 mg (72% yield), mp=142 °C.

5

Preparative Example 2

N-(1'-carboxy-2'-phenylethyl)-bicyclo[2.2.2]oct-5-en-2,3-dicarboximide



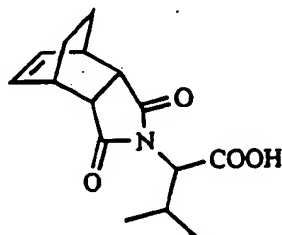
10 To a solution of maleic anhydride (10.30 g, 105.0 mmol) in toluene (100 mL) was added 1,3-cyclohexadiene (8.41 g, 105.0 mmol). The mixture was heated to reflux temperature and allowed to react for 3 hrs. After cooling to room temperature, the solvent was evaporated and the remaining solid was recrystallized from EtOAc/hexane to yield pure bicyclo[2.2.2]oct-5-en-2,3-dicarboxylic anhydride
15 as colorless crystals: 14.11 g (75% yield), mp=117 °C.

To a suspension of L-phenylalanine (502 mg, 3.0 mmol) in H_2O (15 mL) was added a solution of K_2CO_3 (252 mg, 1.8 mmol) in H_2O (3 mL) and the mixture was stirred until a homogeneous solution was obtained. Bicyclo[2.2.2]oct-5-en-2,3-dicarboxylic anhydride (452 mg, 2.5 mmol) was added and the mixture was
20 heated to reflux temperature and allowed to react for 19 hrs. After cooling to room temperature, the reaction mixture was washed with EtOAc and acidified with conc. HCl until the pH reached 1. The aqueous phase was extracted with EtOAc and the organic phase washed with 5% HCl followed by brine and then dried over Na_2SO_4 . Removal of the solvent gave a colorless solid which was recrystallized from
25 EtOAc/hexane to yield the pure product as colorless crystals: 475 mg (58% yield), mp=161 °C.

Preparative Example 3

N-(1'-carboxy-2'-methylpropyl)-bicyclo[2.2.2]oct-5-en-2,3-dicarboximide

5

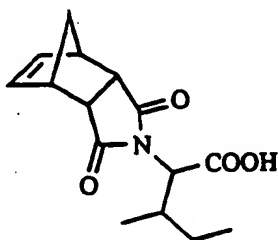


To a suspension of bicyclo[2.2.2]oct-5-en-2,3-dicarboxylic anhydride (2.01 g, 11.3 mmol) in H₂O (25 mL) was added (dl)-valine (1.58 g, 13.5 mmol) and a solution of K₂CO₃ (934 mg, 6.8 mmol) in H₂O (3 mL). The mixture was heated to reflux temperature and allowed to react for 4 hrs. After cooling to room temperature, the mixture was washed with EtOAc, acidified with conc. HCl until the pH reached 1 and extracted with EtOAc. The organic layer was washed with 5% HCl followed by brine and then dried over Na₂SO₄. Removal of the solvent gave a beige solid which was recrystallized from EtOAc/hexane to yield the product as off-white crystals: 1.72 g (55% yield), mp=156 °C.

Preparative Example 4

N-(1'-carboxy-2'-methylbutyl)-bicyclo[2.2.1]hept-5-en-2,3-dicarboximide

20



To a suspension of (dl)-isoleucine (2.03 g, 15.5 mmol) in toluene (40 mL) was added triethylamine (2.4 mL, 17.2 mmol). The mixture was heated to reflux temperature and bicyclo[2.2.1]hept-5-en-2,3-dicarboxylic anhydride (2.53 g, 15.5

25

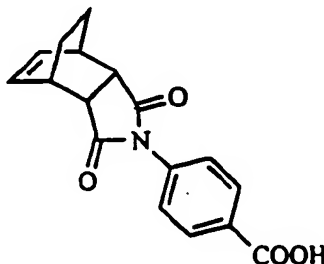
mmol) was added. The reaction mixture was kept at reflux temperature and allowed to react for 4 hrs. After cooling to room temperature, the solvent was evaporated and the residue dissolved in H₂O. The aqueous solution was washed with EtOAc, acidified with conc. HCl until pH=1, and extracted with EtOAc. The organic phase was washed with 5% HCl and brine and dried over Na₂SO₄. Removal of the solvent gave a white solid (3.72 g) which was recrystallized from EtOAc/hexane to yield the pure product as colorless crystals: mp=109 °C.

In the following Examples and Comparative Examples, various compositions of polyolefins and clarifying and/or nucleating additives were prepared. The compositions were evaluated by measuring crystallization properties using Differential Scanning Calorimetry (DSC) according to ASTM D-794-85, run at a rate of 20°C/min and by measuring haze using ASTM D 1003-92. All percentages given are in wt% unless otherwise stated.

15

Preparative Example 5

N-(4-carboxyphenyl)-bicyclo[2.2.2]oct-5-en-2,3-dicarboximide



To a solution of K₂CO₃ (5.88 g, 42.5 mmol) in H₂O (100 mL) was added 4-aminobenzoic acid (5.83 g, 42.5 mmol) and bicyclo [2.2.2]oct-5-en-2,3-dicarboxylic anhydride (7.20 g, 40.4 mmol). The reaction mixture was stirred at room temperature for 18 hrs. and then washed with ethylacetate (EtOAc) (75 ml.). The aqueous phase was acidified with conc. HCl until the pH reached 1. The precipitated crystals were filtered and dried: 11.77 g (98%), mp=269°C.

25

Formulation Example

A composition of the invention was made in a Haake Rheocord 90 melt mixer by combining 0.950 g of the compound of Preparative Example 1 with 190 g

of Quantum™ 8310 GO, available from Quantum Chemical Co., Cincinnati, OH. The polymer was a random copolymer with 3% ethylene and contained an additive package of 300 ppm Irganox™ 1010 antioxidant, 500 ppm Ultrinox™ 626 antioxidant and 1000 ppm calcium stearate.

- 5 The composition was mixed for three minutes at 200°C and 15 rpm and for an additional five minutes at 170°C at 50 rpm with a one minute transition period between the two sets of conditions.

 The crystallization parameters of the composition were determined by DSC. A sample was heated to 200°C, held for 10 minutes, and cooled at a rate of 20°C
10 per minute to about 40°C. Crystallization temperature at onset and peak temperature were recorded.

 To determine clarification ability of the composition, a compression molded haze plaque was prepared by heating 6.5 -7 g of the composition to 200°C for three minutes on a Carver hotpress. The sample was then pressed to (10,000 psi) with a
15 0.5mm spacer for four minutes. The plaque was then water cooled to 20-25°C. Percent haze was then measured on a BYK Gardener XL-211 Hazegard System to determine the haze.

 A similar method was used to prepare similar compositions from polyolefin and the compounds described in Table 1.

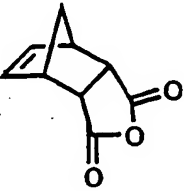
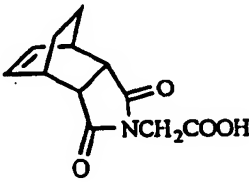
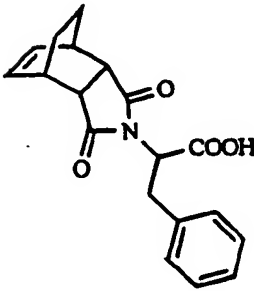
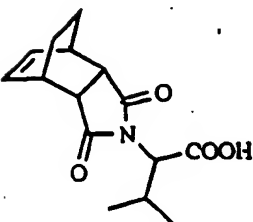
20

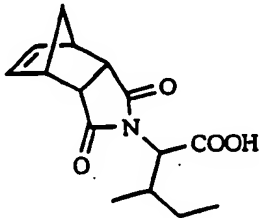
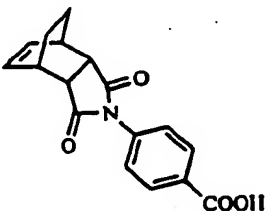
Control Example

 In the Control Example, a compression molded plaque was made in a manner similar to that described in the Formulation Example except that no nucleating or clarifying agent was used. The % haze of the control material was
25 determined by preparing a plaque using a Cincinnati Milacron 50 ACT-D injection molding machine. The machine operated at 230°C and the mold was maintained at 32°C. After about 30 seconds, the 1.2mm thick plaque was ejected from the mold and evaluated as above.

 A variety of nucleating/clarifying agents were compounded with polyolefin
30 and evaluated for haze and crystallinity as described in the above Formulation Example. The results are reported in Table 1.

Table 1: Cyclopentadiene/Cyclohexadiene Derived Anhydrides and Imide Acids as Nucleators/Clarifiers

Entry	Additive	Additive Conc. (%w/w)	Cryst. Temp. (DSC onset) [°C]	Cryst. Temp. (DSC peak max) [°C]	% Haze
A	none	-	97.1	89.8	55
B		0.25	109.2	105.2	36
C		0.5	115.7	109.5	38
D		0.5	116.8	111.6	22
E		0.5	105.2	100.0	22

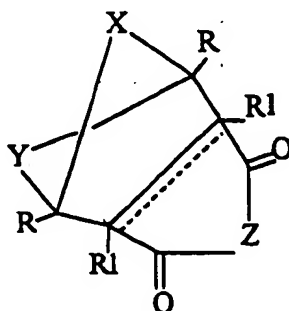
Entry	Additive	Additive Conc. (%w/w)	Cryst. Temp. (DSC onset) [°C]	Cryst. Temp. (DSC peak max) [°C]	% Haze
F		0.5	104.4	99.0	42.5
G		0.5	108.4	102.7	48.9

The foregoing specification and examples provide a complete description of the invention. However, because many variations are possible without departing from the spirit and scope of the invention, the invention resides solely in the claims

5 which follow.

WE CLAIM:

1. A composition comprising a polyolefin and an effective amount of a modifying agent, said modifying agent comprising a compound of formula (I):



(I)

5 wherein X is selected from

C₁₋₁₈ alkylene,
C₂₋₁₈ alkenylene,
C₃₋₁₈ cycloalkylene,
C₄₋₁₈ cycloalkenylene,
arylene, and
-O-;

10

Y is selected from

C₁₋₁₈ alkylene,
C₂₋₁₈ alkenylene,
C₄₋₁₈ cycloalkylene,
C₃₋₁₈ cycloalkenylene, and
arylene;

15

Z is selected from

-O- and -NR₂-;

20 each R is independently selected from

-H,
C₁₋₁₈ alkyl,
C₃₋₁₈ cycloalkyl,
C₂₋₁₈ alkenyl,
C₄₋₁₈ cycloalkenyl,

25

-COR3,
-OH,
C₁₋₁₈ alkoxy, and
C₁₋₁₈ alkyl substituted by one or more
-OH, halogen, -COR3, -S-C₁₋₁₈ alkyl,
aryl, or substituted aryl groups;

5

each R1, if present, is independently selected from

-H,
C₁₋₁₈ alkyl,
C₃₋₁₈ cycloalkyl,
halogen, and
-OH;

10

15 each R2 is independently selected from

C₁₋₁₈ alkyl substituted by one or more
-COR3, and optionally one or more
aryl or substituted aryl,
C₁₋₁₈ alkyl substituted by one or more
-OH, halogen, or -C₁₋₁₈ alkylene-
-S-C₁₋₁₈ alkyl,
-OH,
an other-than-linear-alkyl-substituted
aryl, and
-O-C₁₋₁₈ alkyl, optionally substituted
by NR4R5;

20

25

each R3 is independently selected from -OH, -O-C₁₋₁₈ alkyl, -O-aryl, -O-substituted
aryl, or -NR4R5;

30

R4 and R5 are independently -H, C₁₋₁₈ alkyl, C₃₋₁₈ cycloalkyl, aryl, or
substituted aryl; or a salt thereof.

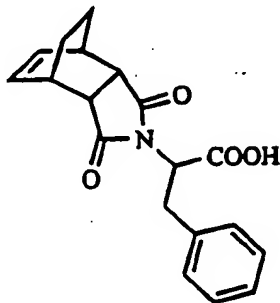
2. The composition of claim 1, wherein X is C_{1-18} alkylene and Y is C_{1-18} alkenylene.

5 3. The composition of claim 1, wherein X is $-CH_2CH_2-$ and Y is $-CH=CH-$.

4. The composition of claim 1, wherein X is $-CH_2-$ and Y is $-CH=CH-$.

10 5. The composition of claim 3, wherein Z is $-NR_2$.

6. The composition of claim 1, wherein the compound of formula (I) has the following structure:



15 7. The composition of claim 1, wherein Z is $-NR_2$ and R_2 is $-OH$.

8. The composition of claim 1, wherein X and Y are both 1,2-phenylene.

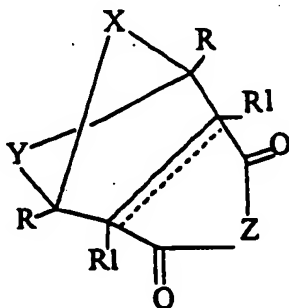
20 9. The composition of claim 1, wherein each R_1 is Cl.

10. The composition of claim 1, wherein the polyolefin comprises a copolymer of propylene and ethylene.

11. The composition of claim 1, wherein the modifying agent is present in an amount in the range from about 0.001 to 1 wt.-%, based on the total weight of the composition.

5 12. The composition of claim 1, wherein the modifying agent is present in an amount in the range from about 0.15 to 0.7 wt.-%, based on the total weight of the composition.

10 13. A method of enhancing the physical properties of a polyolefin, the method comprising the step of adding an effective amount of a compound of formula (I):



(I)

wherein X is selected from

C₁₋₁₈ alkylene,
C₂₋₁₈ alkenylene,
C₃₋₁₈ cycloalkylene,
C₄₋₁₈ cycloalkenylene,
arylene, and
-O-;

15

20 Y is selected from

C₁₋₁₈ alkylene,
C₂₋₁₈ alkenylene,
C₄₋₁₈ cycloalkylene,
C₃₋₁₈ cycloalkenylene, and
arylene;

25

Z is selected from

-O- and -NR₂-;

each R is independently selected from

-H,

C₁₋₁₈ alkyl,

C₃₋₁₈ cycloalkyl,

C₂₋₁₈ alkenyl,

C₄₋₁₈ cycloalkenyl,

-COR₃,

-OH,

C₁₋₁₈ alkoxy, and

C₁₋₁₈ alkyl substituted by one or more

-OH, halogen, COR₃, -S-C₁₋₁₈ alkyl,
aryl, or substituted aryl;

15

each R₁, if present, is independently selected from

-H,

C₁₋₁₈ alkyl,

C₃₋₁₈ cycloalkyl,

halogen, and

-OH;

20

each R₂ is independently selected from

C₁₋₁₈ alkyl substituted by one or more

-COR₃, and optionally one or more
aryl or substituted aryl,

C₁₋₁₈ alkyl substituted by one or more

-OH, halogen, or -C₁₋₁₈ alkylene-

-S-C₁₋₁₈ alkyl,

-OH,

25

30

an other-than-linear-alkyl-substituted
aryl, and
-O-C₁₋₁₈ alkyl, optionally substituted
by NR₄R₅;

5

each R₃ is independently selected from -OH, -O-C₁₋₁₈ alkyl, -O-aryl, -O-substituted
aryl, or -NR₄R₅;

R₄ and R₅ are independently -H, C₁₋₁₈ alkyl, C₃₋₁₈ cycloalkyl, aryl, or
substituted aryl; or a salt thereof.

10

14. The method of claim 13, wherein X is C₁₋₁₈ alkylene and Y is C₁₋₁₈
alkenylene.

15. The method of claim 13, wherein X is -CH₂CH₂- and Y is -CH=CH-.

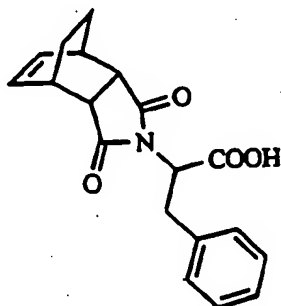
15

16. The composition of claim 13, wherein X is -CH₂- and Y is
-CH=CH-.

17. The method of claim 15, wherein Z is -NR₂.

20

18. The method of claim 13, wherein the compound of formula (I) has
the following structure:



19. The method of claim 13, wherein Z is -NR₂ and R₂ is -OH.

25

20. The method of claim 13, wherein X and Y are both 1,2-phenylene.
21. The method of claim 13, wherein each R1 is Cl.
- 5 22. The method of claim 13, wherein the polyolefin comprises polypropylene.
23. The method of claim 13, wherein the modifying agent is added to the polyolefin in an amount in the range from about 0.001 to 1 wt.-%, based on the
10 total amount of compound and polyolefin.
24. The method of claim 13, wherein the modifying agent is added to the polyolefin in an amount in the range from about 0.15 to 0.7 wt.-%, based on the
total amount of compound and polyolefin.

15

AMENDED CLAIMS

[received by the International Bureau on 8 December 1997 (8.12.97);
new claims 25 and 26 added; remaining claims unchanged (1 page)]

20. The method of claim 13, wherein X and Y are both 1,2-phenylene.
21. The method of claim 13, wherein each R1 is Cl.
- 5 22. The method of claim 13, wherein the polyolefin comprises polypropylene.
23. The method of claim 13, wherein the modifying agent is added to the polyolefin in an amount in the range from about 0.001 to 1 wt.-%, based on the
10 total amount of compound and polyolefin.
24. The method of claim 13, wherein the modifying agent is added to the polyolefin in an amount in the range from about 0.15 to 0.7 wt.-%, based on the total amount of compound and polyolefin.
- 15 25. The composition of claim 1, further comprising an antioxidant.
26. The method of claim 13, further comprising the step of adding an antioxidant.

20

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US 97/07482

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 C08K5/15 C08K5/3417 C08L23/02

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 C08K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	GB 2 290 296 A (SANDOZ) 20 December 1995 see page 2, paragraph 4 - page 3, paragraph 1 see examples 8,24,28	1-15
X	see page 23; claims 1,4,5,8; figure VI	1-5,10, 13,15
A	FR 2 656 620 A (M & T CHEMICALS) 5 July 1991 see page 4, paragraph 2; claims 1,4,8,10 -----	1,3,5, 10,13

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents:

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

- *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
- *Z* document member of the same patent family

Date of the actual completion of the international search

25 September 1997

Date of mailing of the international search report

- 8. 10. 97

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+ 31-70) 340-2040, Tx. 31 651 epo nl.
Fax: (+ 31-70) 340-3016

Authorized officer

Engel, S

INTERNATIONAL SEARCH REPORT

Information on patent family members

Int. onal Application No
PCT/US 97/07482

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
GB 2290296 A	20-12-95	DE 19520262 A FR 2721036 A JP 8012809 A	14-12-95 15-12-95 16-01-96
FR 2656620 A	05-07-91	NONE	